


SPLIT L



Date: Monday, 10/22/2007 10:34:37 AM
User: Kim Johnston



Process Sheet



Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP WELDMENT	<div style="border: 1px solid black; border-radius: 50%; width: 40px; height: 40px; display: flex; align-items: center; justify-content: center; margin: 0 auto;">1</div> <p>OK PER REV. C 07.10.22 DC</p>
Job Number	: 35263	Part Number	: D3562042	
Estimate Number	: 12577 -2	Drawing Number	: D3562 UNDER REVIEW	
P.O. Number	: N/A	Project Number	: N/A	
This Issue	: 10/22/2007 S.O. No. : N/A	Drawing Revision	: C	
Prsht Rev.	: NC	Material	: N/A	
First Issue	: N/A	Due Date	: 11/10/2007	Qty: 8 Um: Each
Previous Run	: 34270	Type	: LARGE FAB ASSY	
Written By	: <u>[Signature]</u>	Checked & Approved By	: <u>[Signature]</u> 07.10.22	
Comment	: Est Rev: A New Issue 06-11-09 JLM Est rev B ECN 987 07.10.09 EC	verified by:	DD	



Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :								
1.0	D2622120C	Extrusion								
										
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)</p> <table border="0"> <tr> <td>Qty</td> <td>Part #</td> <td>Description</td> <td>Batch:</td> </tr> <tr> <td>1</td> <td>D2622-120C</td> <td>Extrusion</td> <td>B34694=1 B34816=4</td> </tr> </table> <p>Check Material for any Dents or Defects</p>			Qty	Part #	Description	Batch:	1	D2622-120C	Extrusion	B34694=1 B34816=4
Qty	Part #	Description	Batch:							
1	D2622-120C	Extrusion	B34694=1 B34816=4							

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
		
<p>Comment: LARGE FABRICATION RESOURCE 1</p> <p>1-Cut D2622 extrusion as per Dwg D3562</p> <p>2-Deburr and bevel ends for welding</p>		

3.0	QC5	INSPECT WORK TO CURRENT STEP
		
<p>Comment: INSPECT WORK TO CURRENT STEP</p>		

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		
<p>Comment: HAND FINISHING RESOURCE #1</p> <p>Chemical Conversion Coat as per QSI 005 4.1</p>		

SAD 07-11-06 (5)

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Drawing Name: STEP WELDMENT

Job Number: 35263

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

a.m.

07.11.19

(5)

6.0

D3560042

ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

ARM WELDMENT

B35030

a.m. 07.11.19

5

7.0

D3560044

ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

ARM WELDMENT

B35032

a.m. 07.11.19

5

Batch

8.0

MS20600AD4W4

Blind Rivet



Comment: Qty.: 36.0000 Each(s)/Unit Total: 180.0000 Each(s)

Blind Rivet

batch: 105953

a.m.

07.11.22

5

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

PTO

1- Transfer drill Rivet holes as per dwg D3562.

2-Touch-up rivet holes with alodine as per dwg d3562

3-Rivet legs using Magnabond as per dwg D3562.

*****Ensure to wipe off any excess magnabond *****

a.m.

07.11.22

5

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

a.m. 07.11.22

5

11.0

D2734

206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D2734

End Cap

B34485

12.11.22

1

Date: Monday, 10/22/2007 10:34:37 AM
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Drawing Name: STEP WELDMENT

Job Number: 35263

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod M105058

2-Grind end cap welds flush as per Dwg D3562

Handwritten: 07-11-22 1
07-11-22 1

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Handwritten: PD 07-11-23 ①

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: AL 128 (X)

15.0

POWDER COATING

POWDER COATING



Handwritten: M105914



Handwritten: (IX)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Handwritten: M-1 07/14/23

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: M106030

Handwritten: BR/ 07-11-23 ①

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: MF 02-11-23 ①

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Handwritten: 35957

Handwritten: SD



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

Handwritten: 7/14/23 SD

Date: Monday, 10/22/2007 10:34:37 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 35263

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

190

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

Handwritten signature/initials

Job Completion



Handwritten: U All. 23

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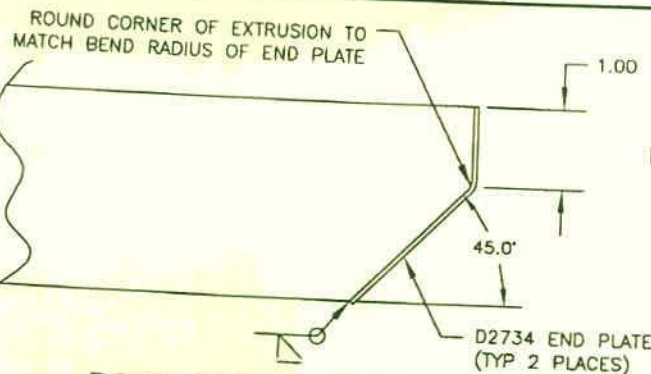
DART

RELEASED
07.06.21-10

UNDER REVIEW

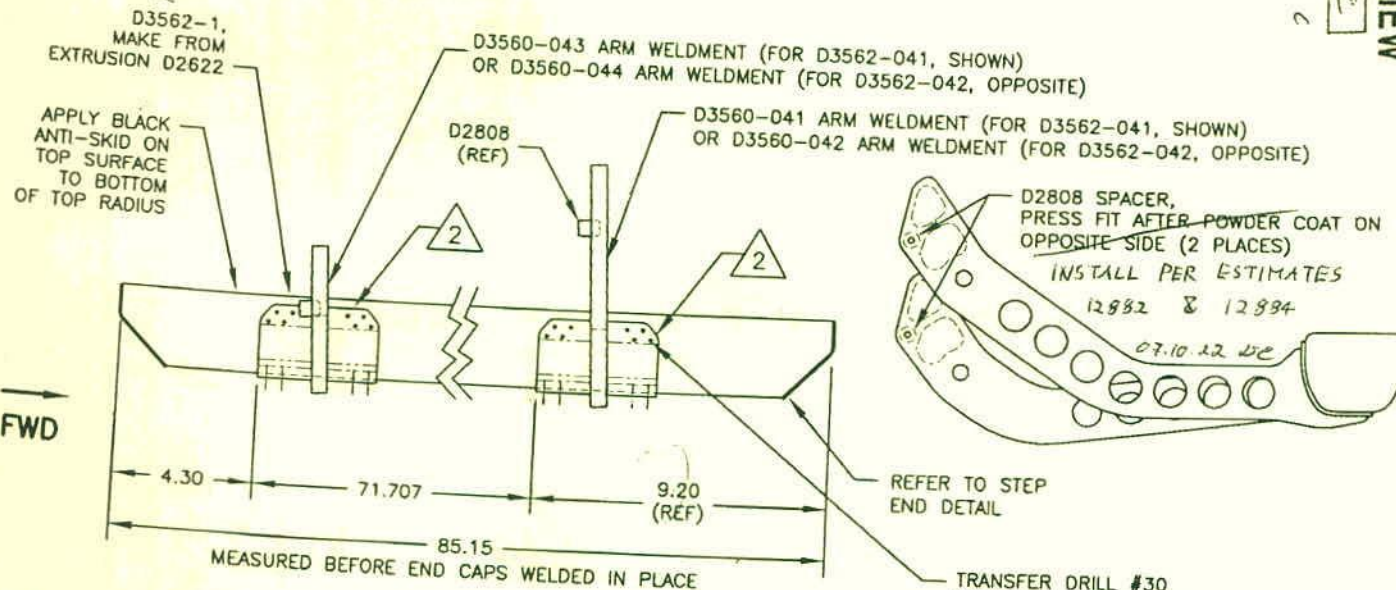
OK PER REV C
07.10.22 DC

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



TYPICAL STEP END DETAIL
NOT TO SCALE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35263



D3562-041 LH STEP ASSEMBLY (SHOWN)
D3562-042 RH STEP ASSEMBLY (OPPOSITE)

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 3) WELD PER DART QSI 004
- 4) FINISH:
 - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
 - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3. TOUCH UP ANY UNFINISHED MAGNOBOND WITH PAINT PER DART QSI 005 4.2
 - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 5) ALL DIMENSIONS ARE IN INCHES

DESIGN	Q7	DRAWN BY	Q7	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	[Signature]	APPROVED	[Signature]	DRAWING NO.	D3562
DATE	07.06.19	TITLE	STEP ASSEMBLY		
A	06.09.26	NEW ISSUE			
B	07.01.15	ARMS NOW RIVETED TO STEP			
C	07.06.19	NOW MAGBND, ADD D2808, RMV 4 RVT'S			

REV. C
SHEET 1 OF 1

